Page 1

October 26, 2009 10:11:54 AM

Item ID:

D2525-5

**Revision ID:** В

Item Name: Spacer

**Start Date:** 

26/10/2009

Start Qty., 10.00

Req'd Civ: 10.00 **Required Date: 03/11/2009** 

OC:

Cust Iter: ID:

Customer:

Reference:

Approvals:

Process Plan:

Date 10-26 Tooling: Date:

Accept

SPC (Y/N):

Date: Date:

Run

Start

Stop

Stop



Sequence ID/ Work Center ID Operation

Description

Set Up/ **Run Hours**  Draw Number Draw Plan Rev. Code

Accept Qty

Reject Qty

Setup Start

Reject Number

Insp. Stamp

Draw Nhr

**Revision Nbr** 

D2525

Rev B

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL Memo

1-Turn Blank as per Dwg D2525 □ 2-Deburr

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00 SNOVID29

0.00 5/0/27

120

QC8- Inspect parts - second check

0.00

Quality Control

Memo

0.00

0.00

. 6

October 26, 2009 10:11:54 AM

Item ID:

٠,

D2525-5

Spacer

В

**Revision ID:** Item Name:

**Start Date:** 

26/10/2009

**Start Oty: 10.00** Req'd Qty: 10.00



Accept



Cust Item ID:

**Customer:** 

Draw

Setup Start



Stop

Reference:

Approvals:

**Required Date: 03/11/2009** 

Process Plan: \_\_\_\_ Date: \_\_\_\_

Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop



Sequence ID/ Work Center ID

130

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo

Set Up/ **Run Hours** 

Draw Number Rev.

Plan Code

Accept Qty

Reject **Qty** 

Reject Insp. Number Stamp

140

QC

Quality Control

QC3- Inspect Part Finish

Memo

000 M 09/10/29

0.00

150

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

gliohe9 Towst

## Work Order ID 53180

В



Page 3

October 26, 2009 10:11:55 AM

**Required Date: 03/11/2009** 

Item ID:

D2525-5

Spacer

Accept



Setup Start



Stop

Item Name: **Start Date:** 

**Revision ID:** 

26/10/2009

QC:

**Start Qty: 10.00** Req'd Qty: 10.00

Operation

Description

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Date:

**Tooling:** 

SPC (Y/N):

Set Up/

Date:

Run

Start

Stop



Sequence ID/

Work Center ID

160

QC21- Final Inspection - Work Order Release

Memo

**Run Hours** 

0.00

0.00

Draw Number Rev.

Date:

Plan Draw Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

09/11/024 MF 09-10-30

Quality Control

## **Picklist Print**

October 26, 2009 10:11:59 AM

Work Order ID: 53180

Parent Item: D2525-5RevB

Parent Item Name: Spacer

Comments:



Start Date: 26/10/2009

**Required Date:** 03/11/2009

Page 1

Start Qty: 10.00

Required Qty: 10.00

s A	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
	M6061T6R0.750		Purchased	No			100	f	99.6753	0.2189			

6061-T6 Round Bar .750"

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehouse			
MAT	99.6753		
110791	2.97		
112041	8.4053		
112442	50		
112663	38.3		

DART AEROSPACE LTD	Work Order:	53180
Description: Spacer	Part Number:	D2525-5
Inspection Dwg: D2525 Rev: B		Page 1 of 1

	FIRST		ARTICLE INSPECTION CHE			CKLIST		
	X	First Arti	cle	Prote	otype			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments	
0.125	+/-0.010	.125						
-Ø <del>0:750</del> -	+0-905/-5-99+							
Ø0.515	+0.008/-0.001	216						
0.450	±,010	.442		-				
·								
	·							
					<u> </u>			
			-					
Measured by:	8/	Audited by	i m	=	Prototype A	pproval:	N/A	

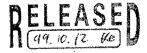
Measured by:	Audited by:	4,000	Prototype Approval:	N/A
Date: (\$/102)	Date:	97/10/29	Date:	N/A

[	Rev	Date	Change	Revised by	Approved
	Α	06.07.05	New Issue	KJ/JLM O	<i>SM</i>

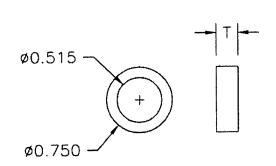


Land St. Dr. Barrell

DESIG	м ВW	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANADA	
CHECK	(ED,	APPROVED	DRAWING NO.	REV. E
	HE.	1 -17	D2525	SHEET 1 OF
DATE	<u>V</u>		TITLE	SCALE
99.0	9.30		SPACER KIT	1:
Α		95.12.22	NEW ISSUE	
В		99.09.30	REVISED MATERIAL	



THICKNESS T	QTY
0.750	1
0.250	1
0.125	4
0.063	0
0.032	0
	0.750 0.250 0.125 0.063



SHOP COPY

RETURN TO

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTE TO WORK ORDER

NO. 53/80

BJ 09-10-24

MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1) OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1